

Date: Thursday, 08/05/2008 12:00:03 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE SPACER
<b>Job Number</b> :	39125		
<b>Estimate Number</b> :	10827		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2877
<b>This Issue</b> :	08/05/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2877 REV B
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	36276	<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	20/05/2008
<b>Written By</b> :		<b>Qty:</b>	120
<b>Checked &amp; Approved By</b> :	JWL 08.5.08	<b>Um:</b>	Each
<b>Comment</b> :	Est B 00.05.19 Added inspect level 8 EC Est C 06.04.26 Water jet EC Est Rev:D Now M6061-T6 06-06-23 JLM Est Rev:E Updated Thickness as per Rev B 06-09-18 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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**Comment:** Qty.: 0.0637 sf(s)/Unit Total: 7.6482 sf(s)

Material: 6061-T6 (QQ-A-250/8) 0.125" Thick

Batch: 106634 RB 8-5-8

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D2877

Dwg Rev: B

Prog Rev: B

2- deburr

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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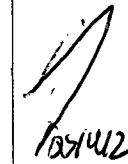

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2877 PAR #: N/A Fault Category: Prod / Process <sup>med & small</sup> NCR: Yes No DQA: AD Date: 08/05/14  
 QA: N/C Closed: AD Date: 08/05/15

NCR: <u>39125</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/12	# 2.0	one part scrap. water jet cut a notch out of one of the Ø.257 holes R.C: Machine Malfunction		Scrap and Destroy no replace Qty (x1)	B 8-5-12	 08/05/12	 12/14/12	 08/05/12

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 39125

Part Number: D2877

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



135

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

RP/FL

08/05/12

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 08/05/12

135

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PC 8/5/12 135

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

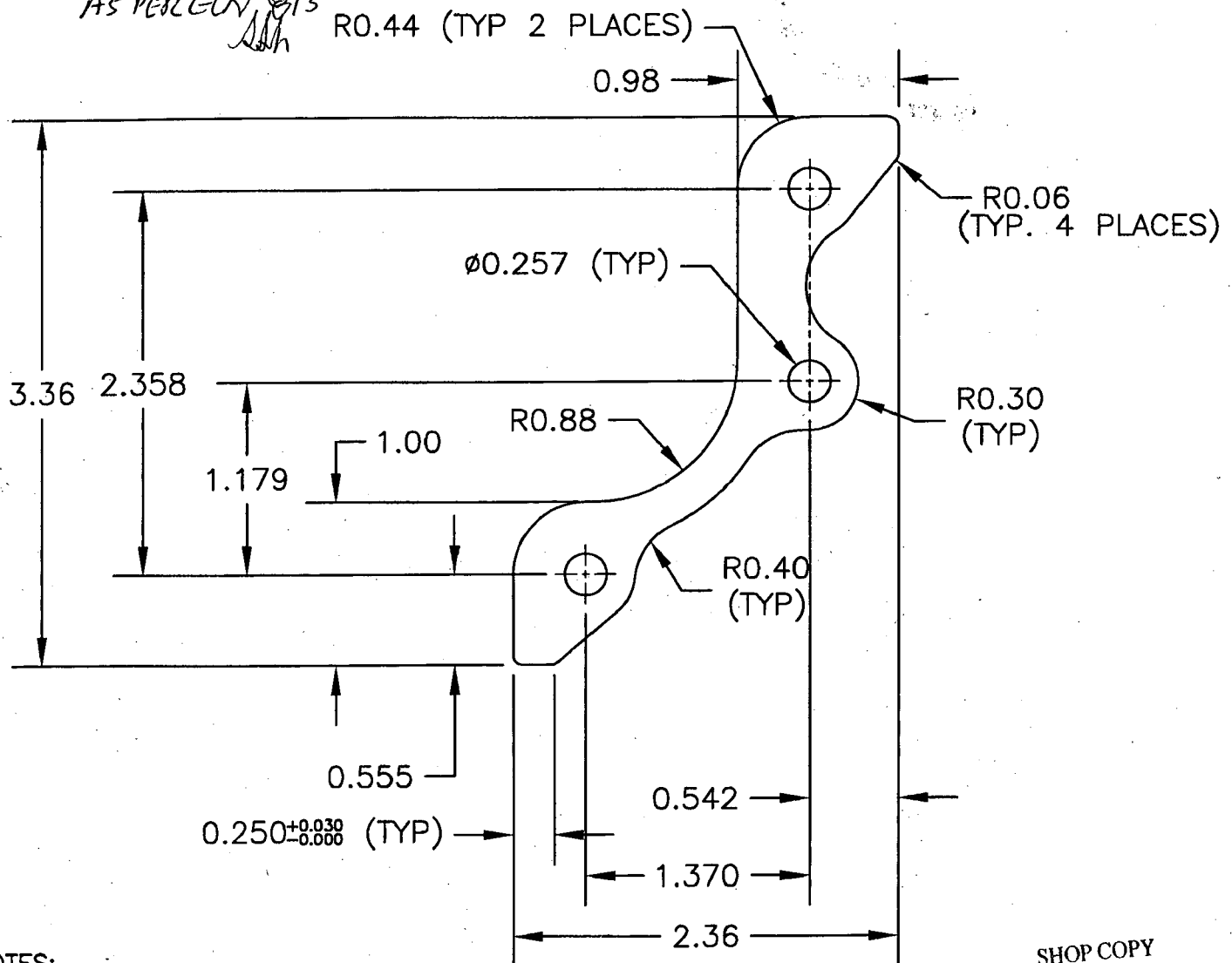
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

**RELEASED**  
*06.06.21.**AS PER ECN 813*  
*[Signature]***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK (REF DART SPEC M6061T6S.125) OR 5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK (REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
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WITHOUT NOTICE  
WORK ORDER  
NO. 39125

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